

Date: Thursday, 2/23/2006 10:21:20 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 25904		Part Number	: D26483		
Estimate Number	: 10313		Drawing Number	: D2648 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/23/2006 S.O. No. : N/A		Drawing Revision	: D		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/20/2006 Qty: 400 Um: Each		
Previous Run	: 24843					
Written By	: See COMMENT BELOW:					
Checked & Approved By	: KJ 06.02.23					
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING	
	Issue P/O: 00000659	<i>Al 06/02/23</i>
	Email or ship DXF file to vendor	
	Make per Drawing D2648-1	
	Material release note required	
2.0	D26483F	Wearpad
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 400.0000 Each(s)	
	WEARPAD	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Receive & Inspect For Transit Damage	
	Ensure material release note is attached	<i>C 04/03/09 ④04</i>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	<i>404</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr if necessary	<i>n/a SB 06/03/16 404</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:21:20 AM
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Drawing Name: WEARPAD

Job Number: 25904

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 06/03/16 404

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat M100452 & M100299

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

M.F Hermine M.

06-04-07

404

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DC 06/04/16

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-04-17

402

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP16

DC 06/04/17

402

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/15

402

11 06/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/04/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/07	7.0	2 scrapped - weld burnt through the wear pad beyond repair. 1st timers.	<i>SD</i> <i>06/04/07</i>	Scrap and destroy	<i>M</i> <i>06/04/07</i>	<i>-</i> <i>06/04/07</i>	<i>B</i> <i>06/04/07</i>	<i>-</i> <i>06/04/07</i>

NOTE: Date & initial all entries

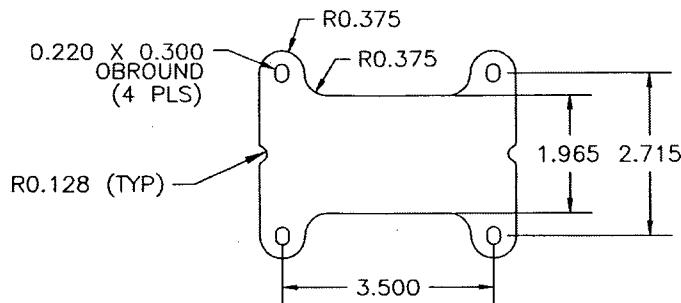
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

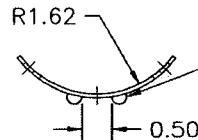
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2648-1 FLAT PATTERN

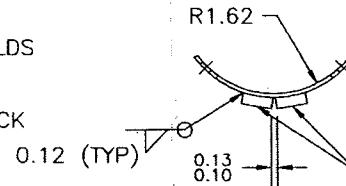


SECTION A-A



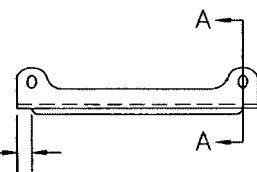
7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B

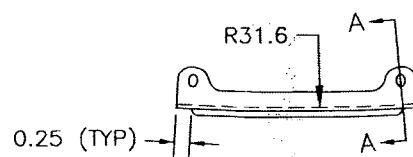


D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

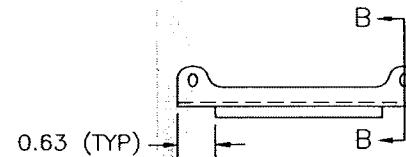
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



RELEASED
99.12.20 DS



D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBRUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. D D2648 SHEET 1 OF 1
DATE		TITLE SCALE 99.11.17 WEARPAD 1:2

WORK ORDER
NO. 25904
SUBJECT TO AMENDMENT
WITHOUT NOTICE

BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



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TEST CERTIFICATE

Ref. 5337/23317

CUSTOMER	Wilkinsen	P50505D1002	SPECIFICATION	ASTM A108 CS Type A	06-03-15	CERTIFICATE No	TC115838																							
CUSTOMER D/N	90-2JN-742		PRODUCT	CRA-WIDE-COIL		PAGE	1 of 1																							
MILL D/N	486948		DIMENSIONS	8.633" x 48" x Coil		DATE	02 August 2005																							
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)																
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r ()	LENGTH (feet)						
		x100												x1000												x10000	x100	180°	G.L.=	HRB
R9-464817-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3				Good				45		2618							
R9-464818-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3				Good				45		2664							
R9-464819-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3				Good				49		2618							
R9-464820-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3				Good				49		2825							
R9-464821-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3				Good				50		1923							
R9-464822-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3				Good				50		1978							

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (E)=2" (D)=5.65 / So (F)=8"	IMPACT TEST (C)=5mm x 5mm (A)=10mm x 10mm (B)=7.5mm x 10mm (D)=2.6mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (C)=C+Mn/8 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+N)/15 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST